

## Stick Electrode for Stainless Steel

# KS-312

### Classification

AWS A 5.4/A5.4M	E312-16
JIS Z3221	ES312-16
EN 3581-A	E 29 9 R
GB T 983	E312-16

Type of coating: Lime titania type

### Applications and Features

- (1) Weld metal is 30%Cr-9%Ni.
- (2) It provides superior weldability, low spatter, easy slag removal and smooth beads.
- (3) It has low crack susceptibility; and, it is suitable for welding stainless steel sheet linings, dissimilar metals, alloy steels with high hardenability and hard-to-weld steel.

### Welding Position

All Positions

### Welding Instruction

- (1) Please refer to Appendix H for re-drying instructions.
- (2) For other instruction information, please refer to Appendix F.

### Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	P	S	Cr	Ni
0.420	0.68	1.64	0.013	0.008	26.70	20.46

### Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation
N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	%
780(79.5)	610(62.2)	25

### Size and Suggested Operating Range (AC or DC+)

Diameter x Length (mm)	2.0x250	2.6x300	3.2x350	4.0x350	5.0x350	
Amp	F/H-Fillet	35~55	50~85	80~120	100~150	140~200
	V-up/OH	30~50	45~85	70~110	90~135	—